

**PRODUCTION OF 5-tert-BUTYL-m-XYLENE**

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**Abstract of JP3024021**

**PURPOSE:** To safely improve the yield with facilitated separation by using a specific catalyst in reacting m-xylene with isobutylene and obtaining the subject compound useful as a synthetic musk raw material or synthetic intermediate for 2,6-dimethylaniline, etc.

**CONSTITUTION:** m-Xylene is reacted with isobutylene in an amount of 0.1-1.0mol, preferably 0.1-0.5mol based on 1mol m-xylene at 80-150 deg.C temperature under a low pressure of ordinary pressure to several kg/cm<sup>2</sup> (especially at about 130 deg.C under ordinary pressure) using activated clay as a reaction catalyst to afford the objective compound. Although ordinary commercially available activated clay is used as the activated clay of the catalyst, a lower moisture content is preferred and especially ≤1wt.% moisture content is the optimum. The catalyst is used in an amount of 1-20wt.%, especially about 10wt.% based on the m-xylene. The reaction is carried out by a method for initially charging the m-xylene and catalyst and then continuously feeding isobutylene gas thereto.

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